

Date: User: ≥Vednesday, 06/12/2006 7:40:34 AM

Linda Lacelle

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number : 29837

Estimate Number P.O. Number

: 10225 :NM

This Issue Prsht Rev.

First Issue

: 06/12/2006

S.O. No. : NIA

: SMALL /MED FAB Type

: 28279 **Previous Run**

Written By Checked & Approved By

Comment

: Est C 00.11.27 Re-format (mpp 2101) EC Now on Waterjet

Est Rev:D 06-08-23

JLM

Drawing Name

: PACKER

: D2150

Part Number

Drawing Number

Material **Due Date** : D2150 REV. A : N/A

Project Number Drawing Revision

: 13/12/2006

40 Um:

Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

2024-T3 .040 sheet

FLOW WATER JET

M2024T3S040 1.0



Comment: Qty.:

0.0263 sf(s)/Unit Total: 1.0500 sf(s)

Material: 2024-T3 (QQ-A-250/4) 0.040" thick

(M2024T3S.040)

Batch: 10102448

ml 06 12 07

M @ 1201

2.0

WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2150

Dwg Rev:__A

Prog Rev: A

06 12 06

2-Deburr if necessary

3.0

QC2



MI OL 12 07 INSPECT PARTS AS THEY COME OFF MACHINE

1 06 12 06

PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5.0 SMALL FAB SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

SAV



Dart Aerospace Ltd

W/O:				WORK	ORD	ER CHANG	GES	3		t		
DATE	STEP		PROCE	DURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							-					
						15.0						
		- 7										
										1		i i

Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	S Date: <u>06/12/1</u> 8
		4	QA: N/C Closed:	Date:

NCR:		W	ORK OR	DER NON-CONFORMANCI	E (NCR)			_
DATE	STEP	Description of NC Section A	Corrective Action Section B Initial Action Description Sign & Date			Verification Section C	Approval Chief Eng	Approval QC Inspector
appliage of DXF was wrong			Scrap & replace	M/ B1207	100/n/00	man	06/13/00	
				•				
								- 4

NOTE: Date & initial all entries

Date: Wednesday, 06/12/2006 7:40:34 AM User: Linda Lacelle **Process Sheet** Drawing Name: PACKER Customer: CU-DAR001 Dart Helicopters Services Job Number: 29837 Part Number: D2150 Job Number: Seq. #: Description: **Machine Or Operation:** HAND FINISHING RESOURCE #1 6.0 HAND FINISHING1 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 POWDER COATING 7.0 M 102391 **Comment: POWDER COATING** Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 INSPECT POWDER COAT/CHEMICAL CONVERSION 8.0 Comment: INSPECT POWDER COAT PACKAGING 1 9.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: FINAL INSPECTION/W/O RELEA 10.0 QC21 Comment: FINAL INSPECTION/W/O RELEASE J Hall-18 Job Completion

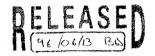
W/O:		WORK ORDER CHAN	WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
Part No	•	PAR #: Fault Category:	NCR: Yes	No DQ	A:	Date: _		
			QA:	N/C Close	d:	Date: _		

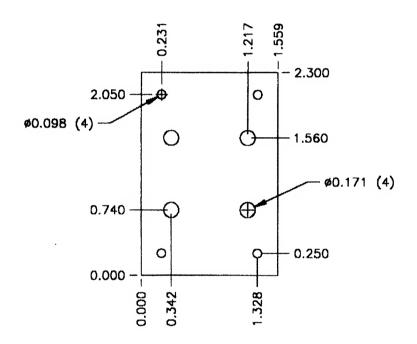
NCR:			WORK ORDE	ER NON-CONFORMANC	E (NCR)							
		Description of NC		Corrective Action Section B		V:6:4:	A					
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspecto				
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								4				

NOTE: Date & initial all entries



	Design B Williams	DRAWN BY K HAND	DART AEROSPACE VICTORIA INTERNATIONAL AIRPORT,		
		APPROVED	DRAWING NO.	***************************************	REV. A
l	Bus	Bul	D2150	SHEET	1 OF 1
	DATE		MLE	***************************************	SCALE
	95:05:01		PACKER		1:1





W/0,32 06,120

MATERIAL: 2024-T3, 0.040 THICK

FINISH: WHITE POWDER COAT HI-GLOSS

DART AEROSPACE LTD	Work Order:	29837
Description: Packs C	Part Number:	D2150
THERE!		
Inspection Dwg: D2150 \Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
\$ 0.098	41-0.004,0.001	0.100			NOVN	
Ø0.171	H-0.005,0.001	0.172	✓		vern	
2.300	1-0.010	9.3∞	1		Vern	
1.559	1-10.010	1.566	1		-124N	
0.250	1-0.010	0.251	1	-	VLVN	
2.050	1+1-0.010	2.051	1		vern	
1.560	1+1-0.010	1.564	J		VEN	·
0.231	4-0.010	0.232	1		VerN	
0.342	+1-0.010	0.344	√		vern !	
1.217	1-1-0.010	1.219	\checkmark		VerN	
0.740	1-0.010	0.739	J		vern	
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Measured by: MA: M	Audited by:	Prototype Approval:
Date: 08 12 07	Date: 06/12/07	Date: VI

Rev	Date	Change	Revised by	Approved
A		New Issue .	KJ/JLM	